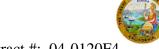
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-017337 Address: 333 Burma Road **Date Inspected:** 11-Oct-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Zhu Zhong Hai. No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A N/A **Electrode to specification:** No Weld Procedures Followed: Yes No Yes N/A **Qualified Welders:** No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** OBG components.

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

Notification no: 006918.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) BK001-PP89-005, 007, 009, 053 and 056.
- 2) BK001-PP91-005, 007 and 009.
- 3) BK001-PP93-005, 007 and 009.

Notification no: 006923.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as

WELDING INSPECTION REPORT

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OBG components. The weld designations reviewed are as follows:

- 1) SEG064B-014, 031, 001, 043.
- 2) SEG064C-014-031, 001 and 044.
- 3) SEG062B-030.
- 4) SEG062C-030

This QA Inspector observed the following work in progress:

OBG Seg 10BE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: LB4-001-075. The welder is identified as 040581 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2314-TC-P4. See attached photo for further details.

The Flux Cored Arc Welding (FCAW) process on weld joint no: LB4-001-044. The welder is identified as 052763 and was observed welding in the 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2332-TC-P4-F.

The SMAW process on weld joint no: TR6B-PP90-004. The welder is identified as 040320 and was observed welding in the 1G position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-P-2211-TC-U4c-FCM-1.

The FCAW process on weld joint no: TR5C-PP89-006. The welder is identified as 047353 and was observed welding in the 3G position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4c-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar, Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer